

Date: Wednesday, 25/03/2009 1:04:17 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PIVOT ARM
Job Number	: 46701		
Estimate Number	: 12771		
P.O. Number	:	Part Number	: 41232 200 002 005
This Issue	: 25/03/2009 S.O. No. :	Drawing Number	: 41232-200-002 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 44347	Material	:
Written By	: <u>JA-03-25</u>	Due Date	: 01/04/2009 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-03-05 JLM		
	: Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified		
	: By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1250	2024-T3 Round Bar 1.250"
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Comment: Qty.: 0.3675 f(s)/Unit Total : 2.2050 f(s)

2024-T3 Round Bar 1.250"

Batch: M110063SN 09/03/252.2 Pt.

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA745 Rev: JA & Dwg 41232-200-002 Rev: A

2-Deburr

09/03/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/03/27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/03/27 (6)

5.0	OUTSIDE SERV 30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING

Issue P/O: 8466

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

09/03/31(6)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 46701

Part Number: 41232 200 002 005

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

9/4/19 (6)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 09/04/13 (6)

8.0 MS21209F410 heli-coil



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
HeliCoil 1/4"-28NF(RED)
Batch: *M108085*

9/4/13

(6)

9.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Install Helicoil as per Dwg 41232-200-005.

FF 09-05-20 (6)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/15/20 (6)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *364*

9/15/20

(4)

SO

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20 (4)

Job Completion



MF 09-05-20

DART AEROSPACE LTD		Work Order:	46701
Description: Pivot Arm		Part Number:	41232-200-002-005
Inspection Dwg: 41232-200-002		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

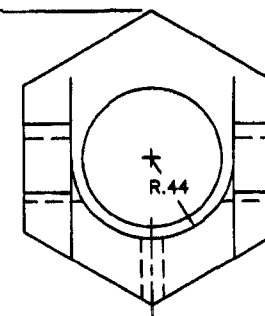
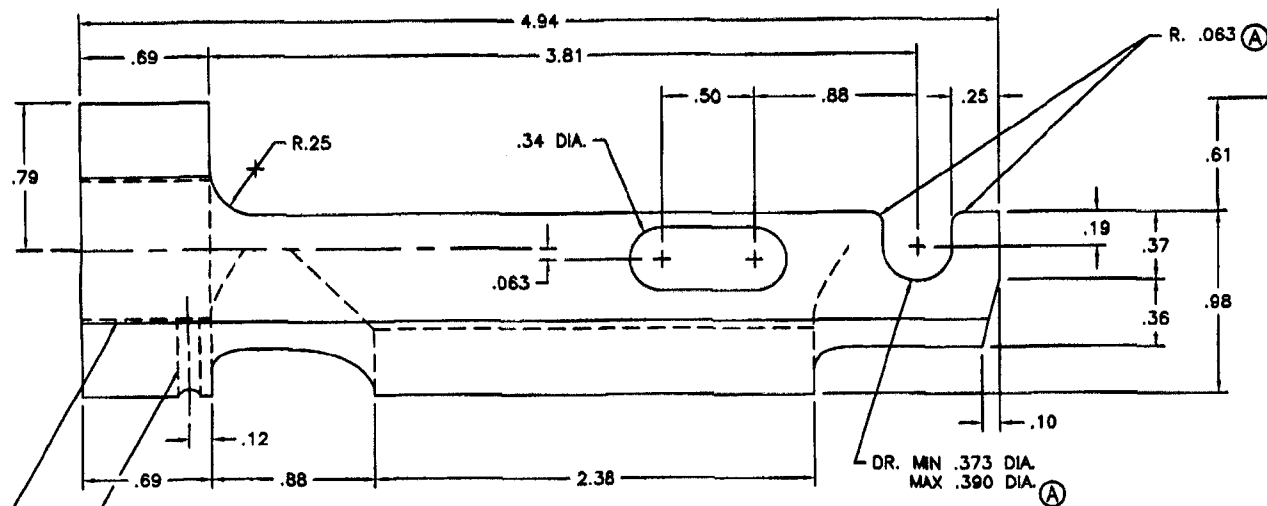
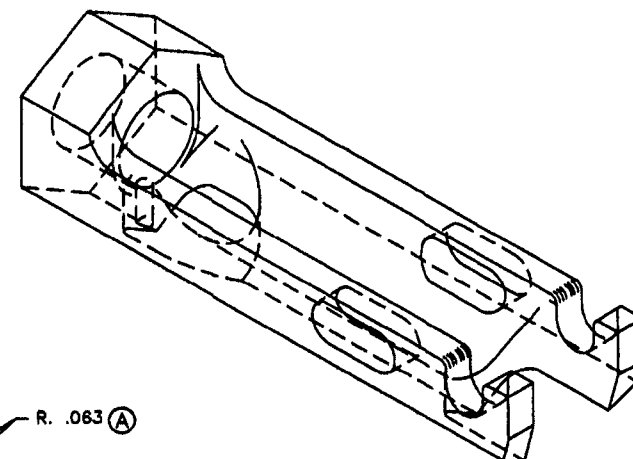
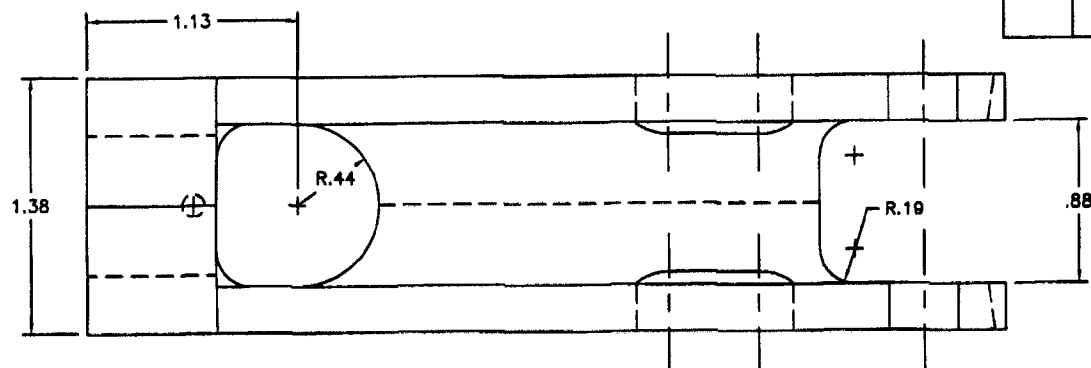
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	.38	✓			
0.25	+/-0.030	.250	✓			
0.38	+/-0.030	.38	✓			
Ø0.375	+/-0.010	.375	✓			
Ø1.00	+/-0.030	1.000	✓			
3.56	+/-0.030	3.56	✓			
1.31	+/-0.030	1.31	✓			
0.63	+/-0.030	.63	✓			
0.50	+/-0.030	.50	✓			
0.38	+/-0.030	.38	✓			
0.31	+/-0.030	.310	✓			
0.19	+/-0.030	.19	✓			
R0.12	+/-0.030	R.12	✓			
Ø0.25	+/-0.030	.250	✓			
1/4-28 HC	N/A	1/4-28	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/03/27	Date:	09/03/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.03	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

REVISION				
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.	
MINOR CHANGE - FAR 21.95			CHECK D. MURPHY	2/17/03



DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D A
TO DRILL HOLE)

3/4"-20 THD.

-001 TUBE

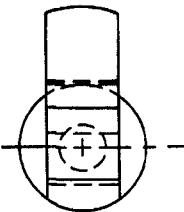
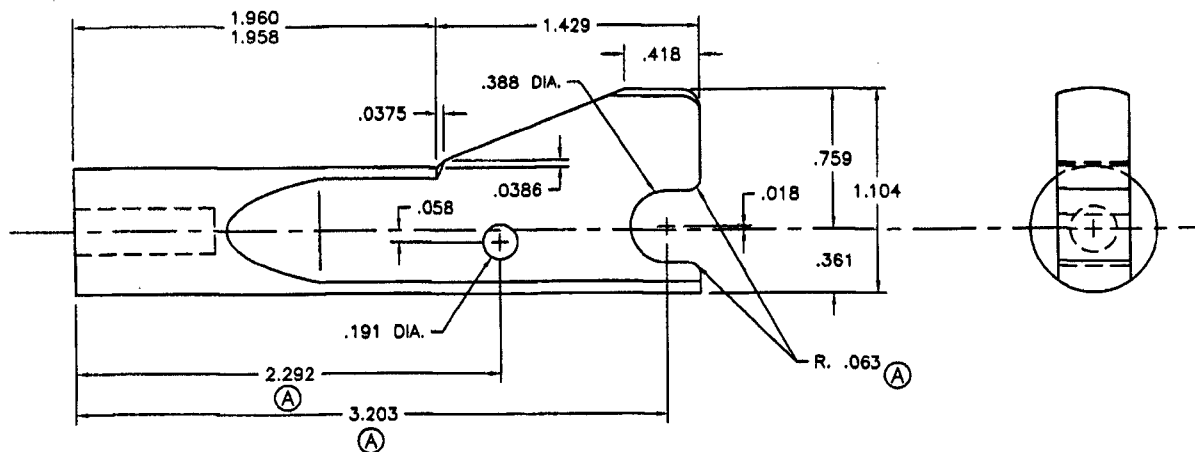
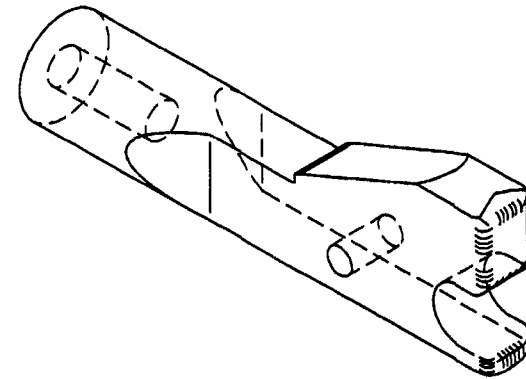
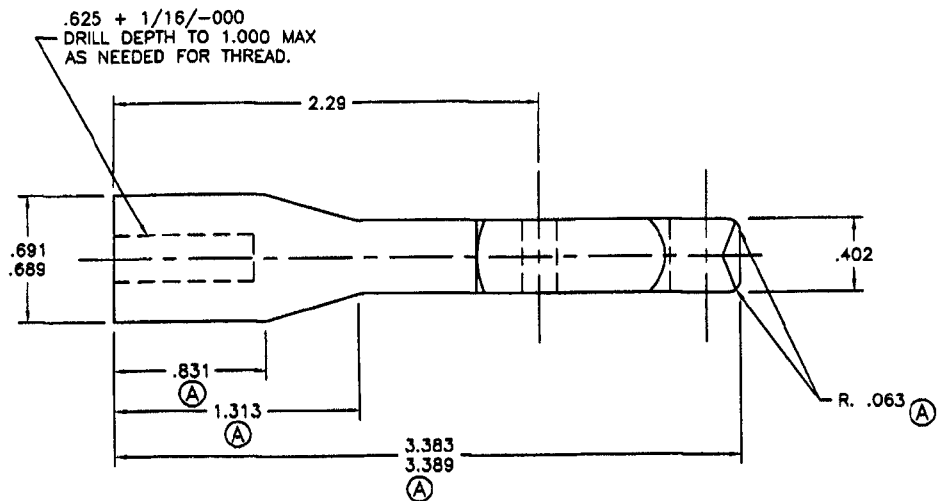
1	MS21209F4-15	INSERT							
	-005	PIVOT ARM	A	1.00 DIA. x 3.58	2024-T4, T351 ALUM.				
	-003	LATCH	A	1.11 x 3.50	2024-T4, T351 ALUM.				
	-001	TUBE	A	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.				
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL	MATLSPEC	ZONE		
LIST OF MATERIAL									
NO. REQ'D PER ASSY									
PROPRIETARY RIGHTS NOTICE									
UNLESS OTHERWISE SPECIFIED									
DRAFTSMAN D. NELSON 2/18/02									
CHECK D. MURPHY 2/18/02									
STRESS									
FRESH									
HEAT TREAT									
FRESH									
2 41232-200-001									
NEXT ASSEMBLY									
STEP ACTUATOR COMPONENTS									
Dwg. No. 41232-200-002									
SHT 1 OF 3									
Rev. A									

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2
DYED BLACK.

NOTE:

46701

Eva Aviation, Inc.



46701

-003 LATCH

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GOING DOES NOT APPLY TO VENDOR PARTS.

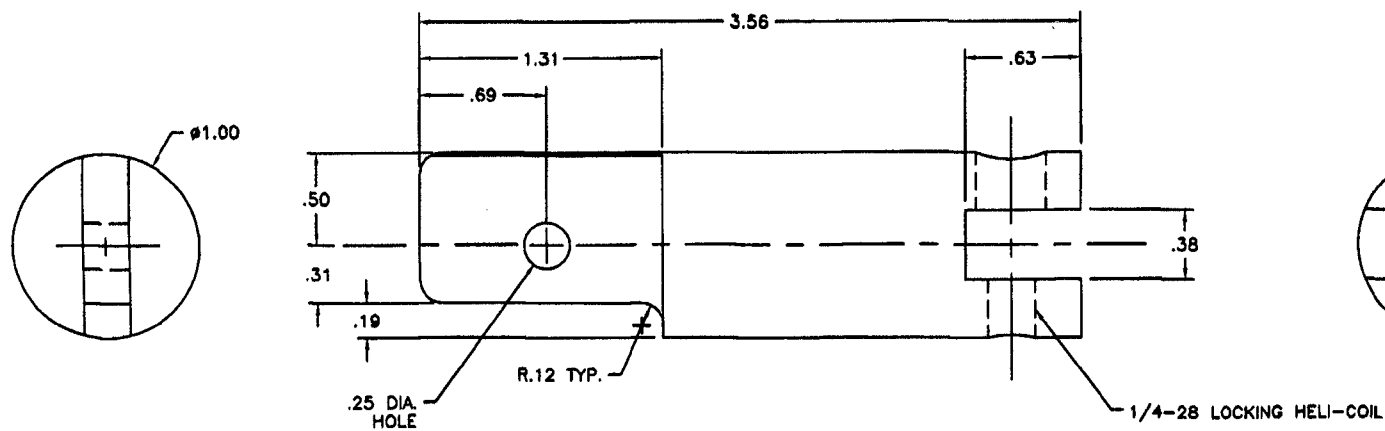
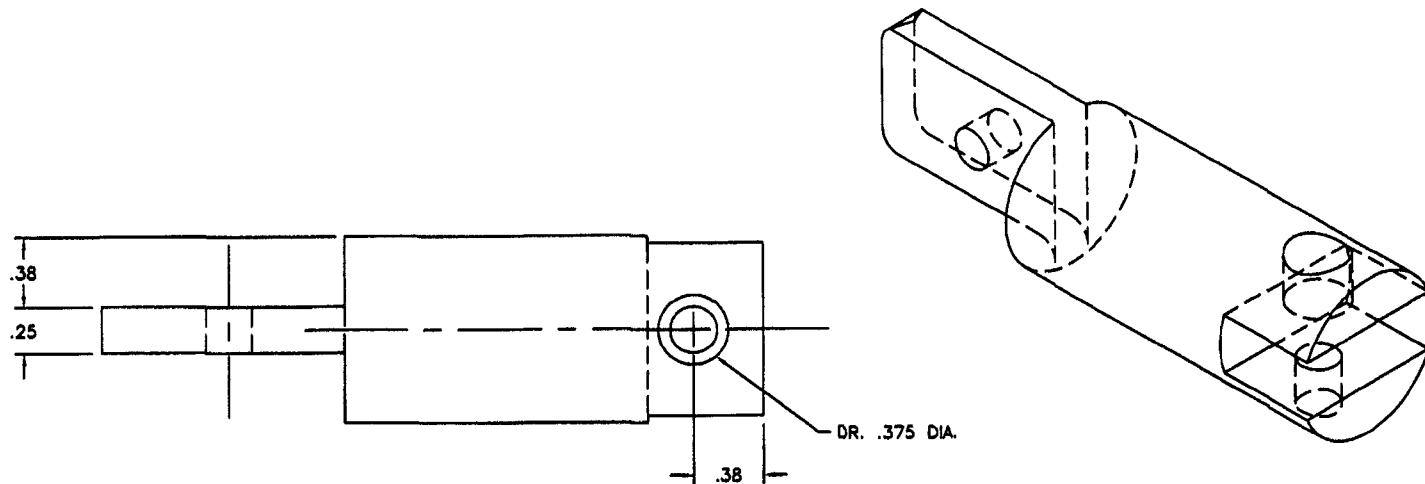
Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DRAW. NO.
41232-200-002
SHT 2 OF 3

REV
A



-005 PIVOT ARM

46701

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Era Aviation, Inc.

TITLE	SIZE	QTY. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 3 OF 3	A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON
-005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

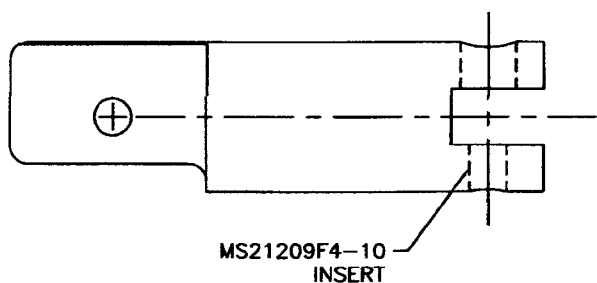
IS

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WAS

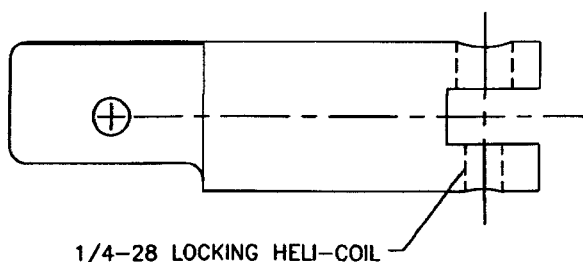
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

46701

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

TNM**ANODISATION et PEINTURE TNM INC.***21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2**Telephone: (514) 429-7777 Fax: (514) 429-5108**Certifié ISO 9001-2000 certified**Certifié NADCAP certified***PACKING****SLIP****73958**

02-Apr-2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:**PURCHASE ORDER/****513764**

ITEM	COMMANDE ORDERED	QUANTITE ORDERED	PARA NUMERO	DESCRIPTION	
1	6	6	41232-200-002-003	B46703	
2	6	6	41232-200-002-005	B46701	

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

73958

02-Apr-2009

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 513764
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	PIECES SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	41232-200-002-003 B46703	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	6	6	41232-200-002-005 B46701	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

S. L. L. S.

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager